

Work Order ID 70059

Thursday, May 26, 2011 9:09:35 AM

Page 1

Item ID: D3811-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Seat Track

Start Date: 5/26/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11/05/26

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3811

Rev A

100



BAND SAW

0.00

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 23.250 " long

cut 11/06/29

8 0

110



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA776Rev: AA & Dwg D3811 Rev: A □2-Deburr
per dwg D3808

B.A 11/08/09

8 0

120



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B.A 11/08/09

8 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3811-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Track

Start Date: 5/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/6/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1-DRILL REMAINIG HOLES	0.00 0.00				8	0		
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				8	0		
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8	1		

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Work Order ID 70059

Thursday, May 26, 2011 9:09:35 AM



Page 3

Item ID:	D3811-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Seat Track				Stop	
Start Date:	5/26/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	6/6/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				8	0	11/08/15	
Hand Finishing	Memo	0.00							
170 Packaging	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
180 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

51262 (4x)

w/o 71009 (2x)
w/o 70901 (2x) } 11/08/15

11/08/15

11/8/16

MF 11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 9:09:40 AM

Page 1

Work Order ID: 70059



Parent Item: D3811-1



Parent Item Name: Seat Track

Start Date: 5/26/2011

Required Date: 6/6/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	107.0000	2	8.421053			



6061-T6 Bar 1.50 x 2.50

Location

Loc Qty

Loc Code

MAT010

107

103069

12

107387

59

16742

36

16
mk 11/06/29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	70059
Description: Seat Track	Part Number:	D3811-1
Inspection Dwg: D3811 Rev: A		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.40	+/-0.030	0.399	✓		Vern	GA-01
6.70	+/-0.030	6.700	✓		Vern	CNC-02
0.700	+/-0.010	0.700	✓		Vern	GA-01
1.400	+/-0.010	1.400	✓		"	"
0.990	+/-0.010	0.990	✓		"	"
Ø0.281 x 0.44 deep	+0.006/-0.001 x +/-0.030	Ø0.283 x 0.447	✓		"	"
0.780	+/-0.010	0.780	✓		"	"
6.48	+/-0.030	6.480	✓		Vern	CNC-02
Ø0.196	+0.005/-0.001	Ø0.198	✓		Vern	CNC-01
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.391 x 100°	✓		Vern	GA-01
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.70	+/-0.030	0.700	✓		Vern	GA-01
6.44	+/-0.030	6.440	✓		Vern	CNC-02
R1.00	+/-0.030	R1.000	✓		R-6	ref.
1.576	+/-0.010	1.576	✓		Vern	GA-01
1.76	+/-0.030	1.770	✓		"	"
10.00	+/-0.030	10.000	✓		Vern	CNC-02
0.590 pitch	+/-0.010	0.589	✓		Vern	GA-01
0.788 pitch	+/-0.010	0.788	✓		"	"
23.00	+/-0.030	23.000	✓		Tape	GA-12
Ø0.323	+0.006/-0.001	Ø0.324	✓		Vern	ML-7
0.27	+/-0.030	0.270	✓		"	"
1.08	+/-0.030	1.080	✓		"	"
20.68	+/-0.030	20.680	✓		M-tape	ML-2
0.44	+/-0.030	0.443	✓		Vern	ML-7
1.24	+/-0.030	1.240	✓		"	"
0.286 x 60°	+/-0.010 x 0.5°	0.296 x 60°	✓		Vern	GA-01
Ø0.388 x 100°	+0.006/-0.001 x 0.5°	Ø0.391 x 100°	✓		"	"
R0.032	+/-0.010	R0.032	✓		R-6	ref.
0.132	+/-0.010	0.132	✓		Vern	GA-01
0.315	+/-0.010	0.316	✓		"	"
0.015 x 30°	+/-0.010 x 0.5°	0.020 x 30°	✓		"	"
0.100	+0.030/-0.010	0.122	✓		"	"
1.98	+/-0.030	1.980	✓		"	"

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	70059
Description: Seat Track		Part Number:	D3811-1
Inspection Dwg: D3811 Rev: A		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.120	+/-0.010	0.120	✓		Vern	GA-01
0.730	+/-0.010	0.734	✓		D-6	GA-02
0.195	+/-0.010	0.197	✓		Vern	GA-01
0.630	+/-0.010	0.632	✓		"	"

Measured by: B.A. / [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/08/09	Date: 11.8.15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ [Signature]	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

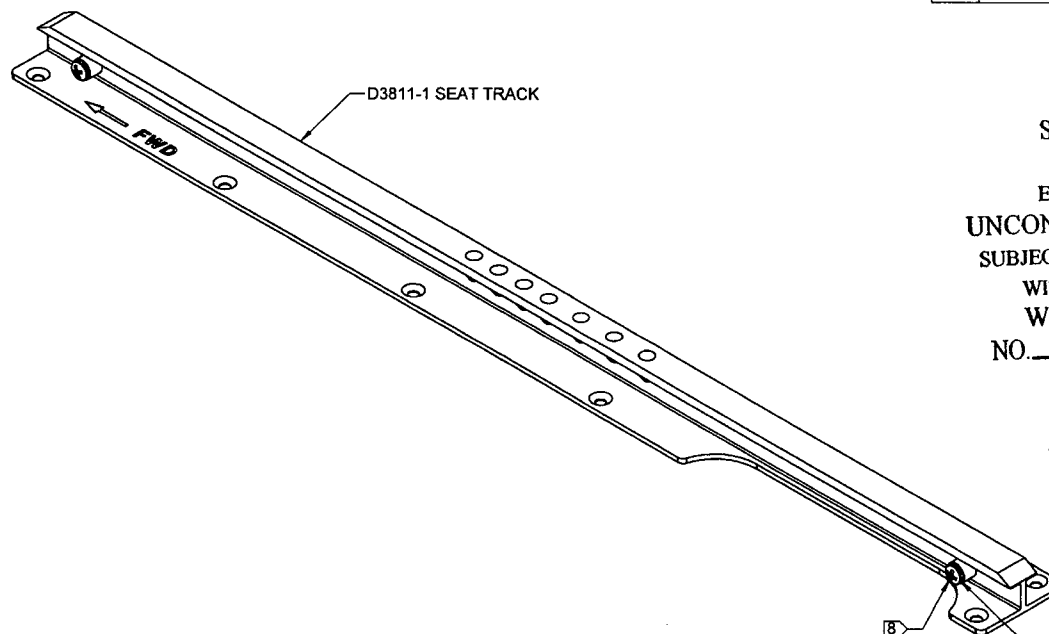
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	P/N	DESCRIPTION
X	D3811-041	SEAT TRACK ASSEMBLY
1	D3811-1	SEAT TRACK
4	D3811-3	BUSHING
2	MS21042L3	NUT
2	MS27039-1-15	SCREW



D3811-041 SEAT TRACK ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70059

PL11-05-26

RELEASED
08-09-30/11

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3811-041 & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.76 lbs
- 8) TORQUE FASTENERS TO 20-25 in-lbs

A	NEW ISSUE	RF	08.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3811	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
DATE	08.08.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

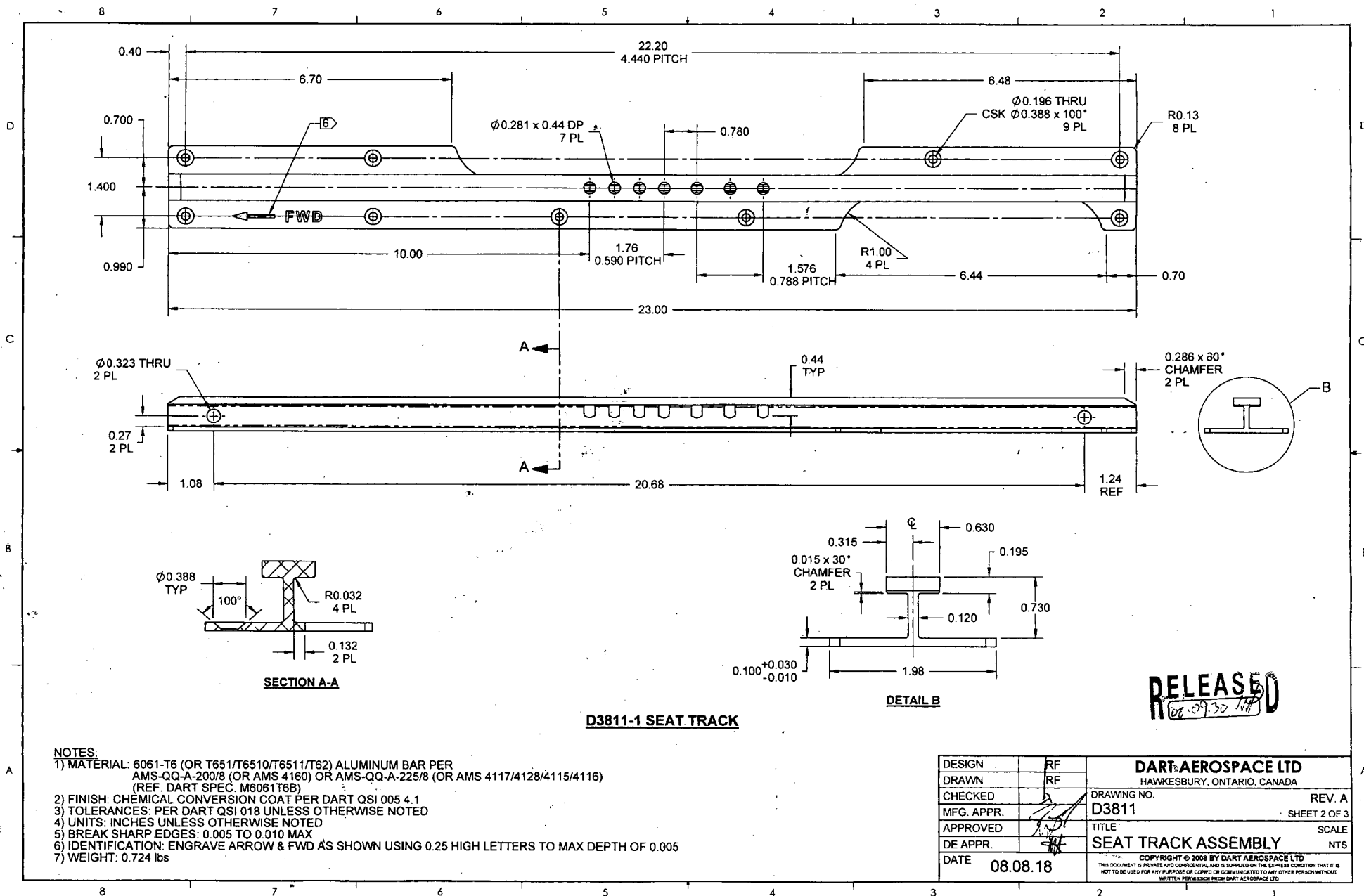
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3811-1 SEAT TRACK

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.25 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.724 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3811	REV. A
MFG. APPR.		TITLE SEAT TRACK ASSEMBLY	SHEET 2 OF 3
APPROVED		SCALE	NTS
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DATE	08.08.18		

RELEASED
08.09.30 147

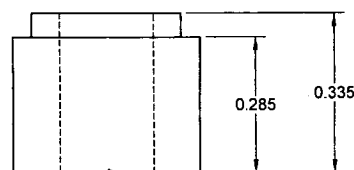
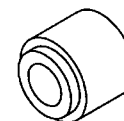
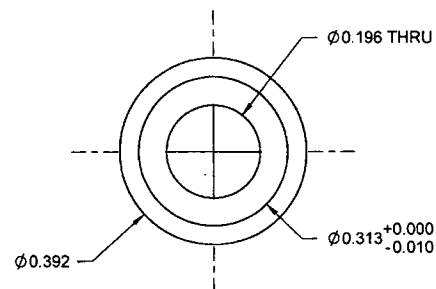
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NOTE: Date & initial all entries



D3811-3 BUSHING

RELEASED
08.09.30/16

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (DART REF. SPEC. M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.003 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3811	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT TRACK ASSEMBLY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries